

**SEMICONDUCTOR STRUCTURE HAVING AN IMPROVED PRE-METAL
DIELECTRIC STACK AND METHOD FOR FORMING THE SAME**

TECHNICAL FIELD

The invention relates generally to a semiconductor structure that includes an improved pre-metal dielectric (PMD) stack, and more specifically to a structure that includes an undoped silicate glass/borophosphorous silicate glass/plasma-enhanced tetraethyl orthosilicate (USG/BPSG/PETEOS) PMD stack and a method for forming the same.

BACKGROUND OF THE INVENTION

10 Semiconductor processes for manufacturing integrated circuits often require forming a protective layer, or layers, to, *e.g.*, reduce contamination by mobile ions, prevent unwanted dopant diffusion between different layers, and isolate elements of an integrated circuit. Typically, such a protective layer is formed with silicon-based dielectrics, such as silicon dioxide, which may take the form of undoped silicate glass (USG), borosilicate glass (BSG), or borophosphorous silicate glass (BPSG). BSG is typically formed by doping USG with Boron. Likewise, BPSG is typically formed by doping USG with both Boron and Phosphorous. If these dielectrics are disposed beneath the first metal layer of 15 the integrated circuit, they are often referred to as pre-metal dielectrics (PMD).

A conventional PMD stack often includes a USG layer disposed on a 20 semiconductor substrate, and a BPSG layer disposed on the USG layer. Typically, a BPSG film layer has a number of advantages over a USG layer. For example, a BPSG layer is often a better moisture barrier than a USG layer. Also, the phosphorous ions in a BPSG layer trap mobile sodium (Na) or other ions. This phenomenon is called "gettering," and it is sometimes used to reduce or eliminate an unwanted shift in a transistor's threshold 25 voltage V_T caused by mobile ions trapped in the gate oxide of the transistor. Additionally, the Boron ions decrease the viscous flow temperature of the BPSG layer. This facilitates reflow of the BPSG layer, and thus improves the reflow planarization of the BPSG layer

surface and allows for the filling of gaps with fewer voids. A downside of BPSG is that Boron and Phosphorous ions may diffuse from the BPSG into an underlying silicon region such as a silicon substrate. Such diffusion may cause undesirable changes in the doping profile of the silicon region. Therefore, to prevent such diffusion, the PMD stack includes
5 a USG layer beneath the BPSG layer. The USG layer acts as a barrier to such diffusion.

Figure 1 is a cross-section of a portion of a conventional semiconductor structure 1. The structure 1 has a patterned field-oxide layer 2 that defines active regions 8 in a semiconductor substrate 10. In one embodiment, the field oxide 2 has a thickness between approximately 3k to 6k angstroms. A gate structure 12 is disposed over the active
10 region 8, and a layer 14 is disposed over a segment of the field oxide 2. A USG layer 4 having a thickness between approximately 1k - 2k angstroms is conventionally formed over the surface of the structure 1. A relatively thick BPSG layer 6 having a thickness between approximately 12k - 25k angstroms is subsequently formed over the USG layer 4. In one embodiment, the thickness of the BPSG layer 6 is at about 18k angstroms.

15 Referring to Figure 2, after the BPSG layer 6 has been formed, the structure 1 is planarized using a conventional chemical mechanical polishing (CMP) process. The CMP process reduces the combined thickness of all layers above the substrate 10, *i.e.*, from the bottom of the field oxide 2 all the way to the top of the BPSG layer 6, to a value y_k . In one embodiment, y_k is approximately 12k angstroms. The layer 4 and the polished layer 6
20 form a PMD stack 17.

Referring to Figure 3, an optional plasma-enhanced tetraethyl orthosilicate (PE-TEOS) redeposition dielectric layer 16 having a thickness between approximately 2k - 4k angstroms may be conventionally formed over the polished BPSG layer 6. Therefore, when present, the layer 16 composes part of the PMD stack 17.

25 As the semiconductor industry increasingly relies on the CMP technique for planarization in today's high-density integrated circuits, drawbacks of the USG/BPSG PMD stack in connection with the CMP technique become more prominent. First, Boron and Phosphorous dopants in the BPSG layer 6 often are not uniformly distributed across and against the depth of the semiconductor wafer. This non-uniform distribution of the

boron and/or phosphorous dopants often causes uneven thickness of the BPSG layer 6 even after CMP. Second, forming the BPSG layer 6, which is typically accomplished by a atmospheric pressure chemical vapor deposition (APCVD) process, is often a low-throughput and high maintenance process. As a result, using a relatively thick sacrificial 5 BPSG layer 6 for the PMD 17 is often burdensome for manufacturing today's high-density integrated circuits. Additionally, the BPSG layer 6 often is too soft for a CMP process to adequately smoothen or planarize the surface of the layer 6.

SUMMARY OF THE INVENTION

In one embodiment of the invention, a semiconductor structure includes a 10 substrate, a dielectric layer disposed over the substrate, an undoped silicate glass layer disposed over the insulator layer, a borophosphorous silicate glass layer disposed over the undoped silicate glass layer, and a planar dielectric layer disposed over the borophosphorous silicate glass, the undoped silicate glass layer, the borophosphorous silicate glass layer; and the planar dielectric layer together forming a pre-metal dielectric 15 stack layer. In one embodiment, the planar dielectric layer includes plasma-enhanced tetraethyl orthosilicate.

BRIEF DESCRIPTION OF THE DRAWING

Figure 1 is a cross-section of a conventional semiconductor structure.

Figure 2 shows the semiconductor structure of Figure 1 after it has been 20 subjected to a CMP process.

Figure 3 shows the semiconductor structure of Figure 2 after the formation of an optional PE-TEOS redeposition layer.

Figure 4 is a cross-section of a semiconductor structure formed according to an embodiment of the invention.

25 Figure 5 shows the semiconductor structure of Figure 4 after it has been subjected to a CMP process.

Figure 6 shows the semiconductor structure of Figure 5 after the formation of an optional PE-TEOS redeposition layer over the polished USG/BPSG/PE-TEOS stack.

DETAILED DESCRIPTION OF THE INVENTION

Figures 4-6 shows a process for forming a PMD stack 20 according to one embodiment of the invention. Like reference numerals are used to reference elements in common with Figures 1-3.

Referring to Figure 4, a layer 38 is formed over the BPSG layer 6 before CMP. In one embodiment, the layer 38 is conventionally formed from plasma-enhanced tetraethyl orthosilicate (PE-TEOS). The layer 38 acts as a sacrificial layer for the CMP process. In one embodiment, the thickness of the layer 38 is between approximately 8k - 20k angstrom, for example about 12k angstroms. The thickness of the BPSG layer 6 is between approximately 1.5k - 8k angstroms, for example 6k angstroms. The thickness of the USG layer 4 is between approximately 1k - 3k angstroms, and the thickness of the field oxide 2 is between approximately 3k - 6k angstroms.

Referring to Figure 5, after the layer 38 is formed, the structure 1 then goes through the CMP process. In one embodiment, the layer 38 is polished until the BPSG layer 6 is exposed. In another embodiment, the polishing stops before the BPSG layer 38 is exposed. In yet another embodiment, the polishing endpoint is empirically determined using a test wafer (not shown). Alternatively, endpoint data provided by the manufacturer of the CMP equipment may be used. After the CMP, the combined thickness y_k of all layers, *i.e.*, measured from the bottom of the field oxide 2 to the top of the layer 38, is between approximately 8k to 15k angstroms. In one embodiment, y_k is approximately 13k angstroms. Thus, the layers 4 and 6 and the polished layer 38 together compose the PMD stack 20.

Referring to Figure 6, subsequent to the CMP, an optional redeposition layer 46 may be formed on the layer 38. In one embodiment, the layer 46 is formed from PE-TEOS, has a thickness of approximately 2k angstroms, and composes part of the PMD 20. In another embodiment, the layer 46 is formed from TEOS.

All subsequent process steps, such as, e.g., opening windows for tungsten plugs and metallization and finishing manufacturing of the semiconductor structure 1, are conventional and are thus not discussed in detail.

- In embodiments where the layer 38 is formed from PE-TEOS, the layer 38
- 5 is often harder than the BPSG layer 6, and thus allows the PMD stack 20 to maintain the advantages of the conventional USG/BPSG stack while eliminating the disadvantages of polishing the BPSG layer 6. Furthermore, PE-TEOS has a higher throughput rate during processing than BPSG. Therefore, when formed from PE-TEOS, the layer 38 aids in reducing the processing time by allowing the BPSG layer 6 to have a reduced thickness.
- 10 Because the thickness of the BPSG layer 6 is reduced, the layer 6 processing time is significantly reduced.

Specifically, in embodiments where the layer 38 is formed from PE-TEOS, the process for PE-TEOS deposition is up to about twice the throughput rate as compared with that of the BPSG deposition process. Furthermore, the PE-TEOS layer 38 is often

15 deposited by using the plasma-enhanced chemical vapor deposition (PECVD) process. Thus, unlike the BPSG process which often requires substantial efforts of equipment cleaning after deposition to avoid defects, equipment for PE-TEOS deposition often require less efforts to clean after deposition. This will cause less down time for the PE-TEOS deposition process than for the BPSG deposition process. In addition, the CMP process

20 normally polishes the PE-TEOS layer 38 more uniformly than it would polish the BPSG layer 6 since there is no problem of non-uniform distribution of boron and phosphorous ions in the PE-TEOS layer 38. Another advantage of the present invention is that the same PE-TEOS deposition recipe can be used in the CMP process for both the PMD stack 20 and later inter-level dielectric (ILD) layers (not shown), which are dielectric layers

25 conventionally formed after first metallization of the semiconductor structure 1. This often simplifies the manufacturing process of the semiconductor structure 1.

Although the detailed description discloses various embodiments of the invention, other embodiments may be made without deviating from the scope of the invention. In particular, the layer 38 may be formed using a High-Density Plasma

Chemical Vapor Deposition (HDPCVD or HDP) technique or even a traditional CVD technique. In alternative embodiments, the respective thicknesses of the layer 38, the USG and BPSG layers 4 and 6, and the field oxide 2 can be fine-tuned to obtain optimal desired characteristics, e.g., gettering effect of mobile ions or to improve the yield of the
5 manufacturing process.

All of the above U.S. patents, U.S. patent application publications, U.S. patent applications, foreign patents, foreign patent applications and non-patent publications referred to in this specification and/or listed in the Application Data Sheet, including but not limited to U.S. Patent Application No. 09/632,388, filed August 3, 2000, and entitled
10 "SEMICONDUCTOR STRUCTURE HAVING AN IMPROVED PRE-METAL DIELECTRIC STACK AND METHOD FOR FORMING THE SAME" and U.S. Patent Application No. 09/061,667, filed April 16, 1998, and entitled "SEMICONDUCTOR STRUCTURE HAVING AN IMPROVED PRE-METAL DIELECTRIC STACK AND METHOD FOR FORMING THE SAME" are incorporated herein by reference, in their
15 entirety.

From the foregoing it will be appreciated that, although specific embodiments of the invention have been described herein for purposes of illustration, various modifications may be made without deviating from the spirit and scope of the invention. Accordingly, the invention is not limited except as by the appended claims.